

# Work Order ID 53675

November 12, 2009 8:18:22 AM



Page 1

Item ID: D3929-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gusset Assembly

Start Date: 12/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 19/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: PS

Date: 09-11-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3929

Rev A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

PS 9-11-12

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

PS 9-11-12

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00				10			69-11-13
130 	Pick Kit	0.00							
Packaging Packaging	Memo	0.00				30	09	11	17.
140 	Large Fab	0.00							
Large Fab	Memo	0.00				SP	09	11	17
	Weld bushings D3907-1 as per dwg D3929								(10X)
	316L rod batch: M 100775								

# Work Order ID 53675

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Item ID: D3929-041

Revision ID: A

Item Name: Gusset Assembly

Start Date: 12/11/2009 Start Qty: 6.00

Required Date: 19/11/2009 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00							<i>Pl 09 11 18</i>
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		<i>2/8 09/11/18</i>					<i>(KCO) /</i>
170  Packaging Packaging	Identify as per dwg & Stock Location: <i>WA</i>  Memo	0.00  0.00		<i>SAD 09-11-19</i>					<i>(10)</i>

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Item ID: D3929-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gusset Assembly

Start Date: 12/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 19/11/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

09/11/19

U 9.11.19

# Picklist Print

November 12, 2009 8:18:27 AM

Page 1

Work Order ID: 53675

Parent Item: D3929-041RevA

Parent Item Name: Gusset Assembly


Comments:

Start Date: 12/11/2009

Required Date: 19/11/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	128.7100	2.8421	4.75		

B 9-11-12

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

128.7099979

111018

0.70999789

112663

128

111018

10

D3907-1RevA

Manufactured

No

130

Each

27.0000

12.0000



Bushing

Sp 09.11.17.

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

27

53138

27

53673

11 X

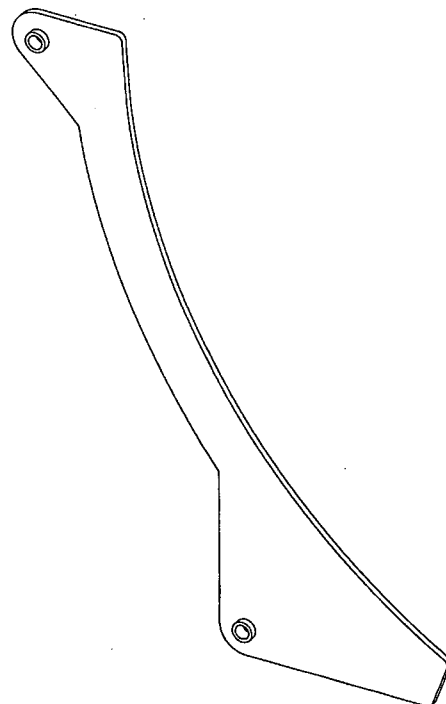
9 X.

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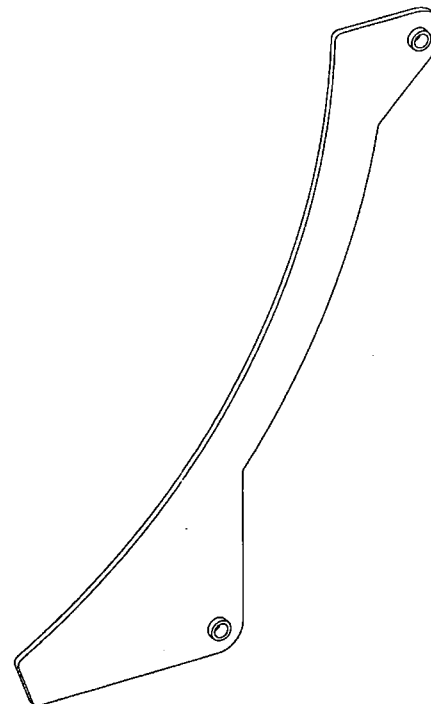
20x



ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



**D3929-041 GUSSET ASSEMBLY**



**D3929-042 GUSSET ASSEMBLY**

SHOP  
RETURN  
ENGINE  
UNCONTROL  
SUBJECT TO  
WITHOUT  
WORK  
NO. 53675  
12/09-11-12

**RELEASED**  
07/04/12 MD

**NOTES:**

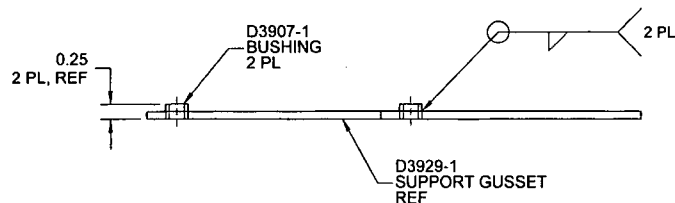
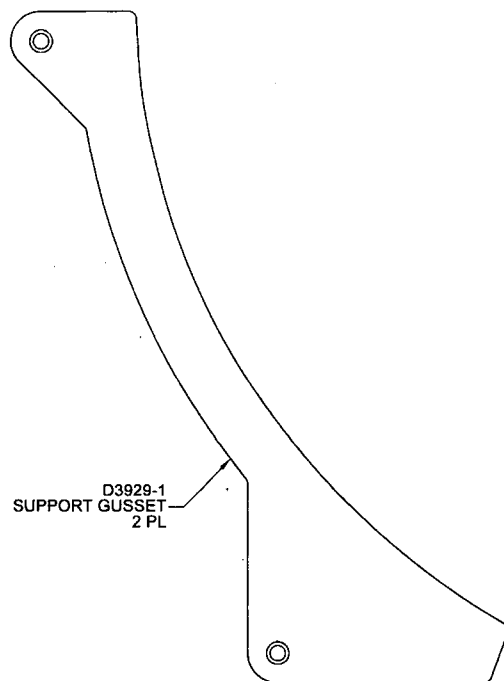
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.03		

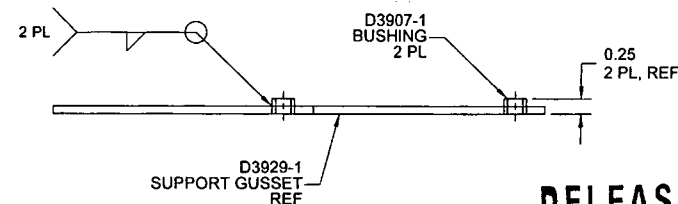
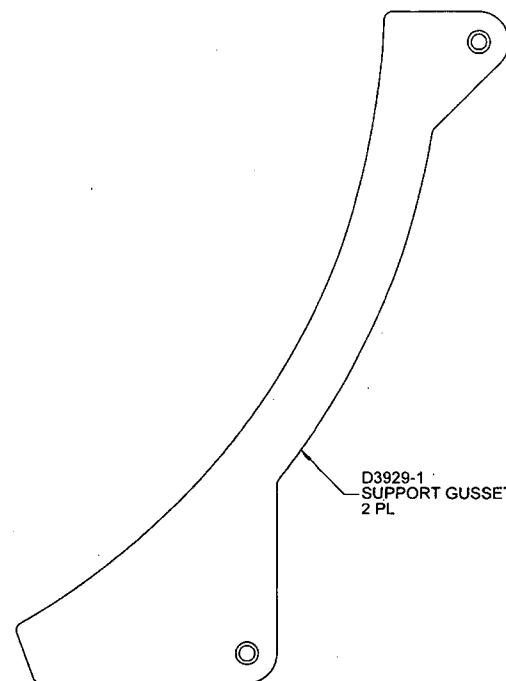
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3929** REV. A  
SHEET 1 OF 3  
TITLE **GUSSET ASSEMBLY** SCALE NTS

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**D3929-041 GUSSET ASSEMBLY**



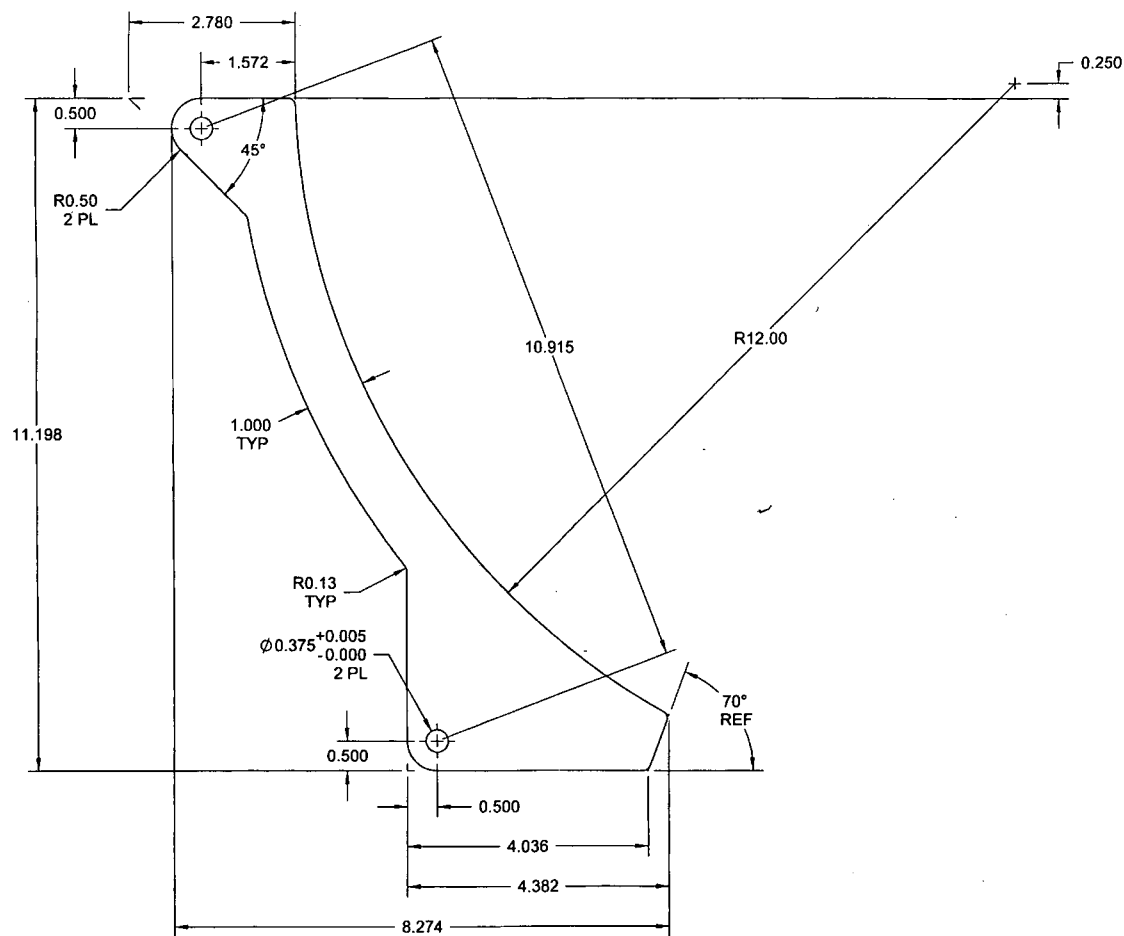
**D3929-042 GUSSET ASSEMBLY**

**RELEASED**  
09/04/22

W/0 53675

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MFG. APPR.		D3929	SHEET 2 OF 3
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DE APPR.		GUSSET ASSEMBLY	NTS
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**D3929-1 SUPPORT GUSSET**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
11 GAUGE (0.125 THICK)  
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

**RELEASED**  
09/04/22

W/D 5.3675

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